

Date: Tuesday, 10/30/2007 2:49:01 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASSEMBLY
Job Number	: 35440		
Estimate Number	: 10439		
P.O. Number	: <i>N/A</i>	Part Number	: D3331041
This Issue	: 10/30/2007 S.O. No. <i>NA</i>	Drawing Number	: D3331 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NA</i> Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 23769	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/15/2007 Qty: 6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: C 05.05.26 Added D3158-050 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1025TR0875W125	1025 Round Steel Bar
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Comment: Qty.: 1.5000 f(s)/Unit Total : 9.0000 f(s)

1025 Round Steel Bar

Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall

(M1025TR0.875W.125)

Batch: *18029V*

*[Signature]* 07/11/14

6x

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- Cut handle to finish length as per Dwg D3331

2- Form as per Dwg D3331 using DT8760 crimping Jig

*[Signature]* 07/11/14

6x

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg D3331

Identify as D3331-1

*[Signature]* 07/11/14

6x

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature]* 07/11/14

6x

5.0	QC8.	SECOND CHECK
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Comment: SECOND CHECK

*[Signature]* 07/11/15

6x

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:49:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 35440

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

238032

3/16" Dowel Pin 1" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

3/16" Dowel Pin 1" long

Pick:

Qty	Part Number	Description	Batch
1	238-032	3/16"-1" long Dowel	M106162 ✓

Batch

M106162 ✓

HS 07/11/15

6x

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Deburr

2- Drill dowel hole as per Dwg D3331

3- Insert and Weld dowel as per Dwg D3331

Qty	Part Number	Description	Batch
A/R	N/A	Steel Rod	M103794

Batch

M103794

HS 07/11/15

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

HS 07/11/15

6

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

M18052

HS 07/11/19

6x

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 07/11/19

6

11.0

GP78R

Black Vinyl Grid



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Black Vinyl Grid

Pick:

Qty	Part Number	Description	Batch
1	GP-78R	Black Vinyl Grid	M180600

Batch

M180600

HS 07/11/22

6x

12.0

D3158

Heat Shrink



Comment: Qty.: 0.4166 f(s)/Unit Total: 2.4996 f(s)

Heat Shrink

Pick:

HS 07/11/22

6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/11/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/30/2007 2:49:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 35440

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description:

Qty Part Number Description  
5" D3158 Heat Shrink

Batch

24615

07/11/22

6x

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Assemble as per Dwg D3331  
Identify as D3331-041

07/11/22

6x

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/23

6x

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 5T487

07/11/23

07/11/23

6x

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/26

6x

Job Completion



07/11/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

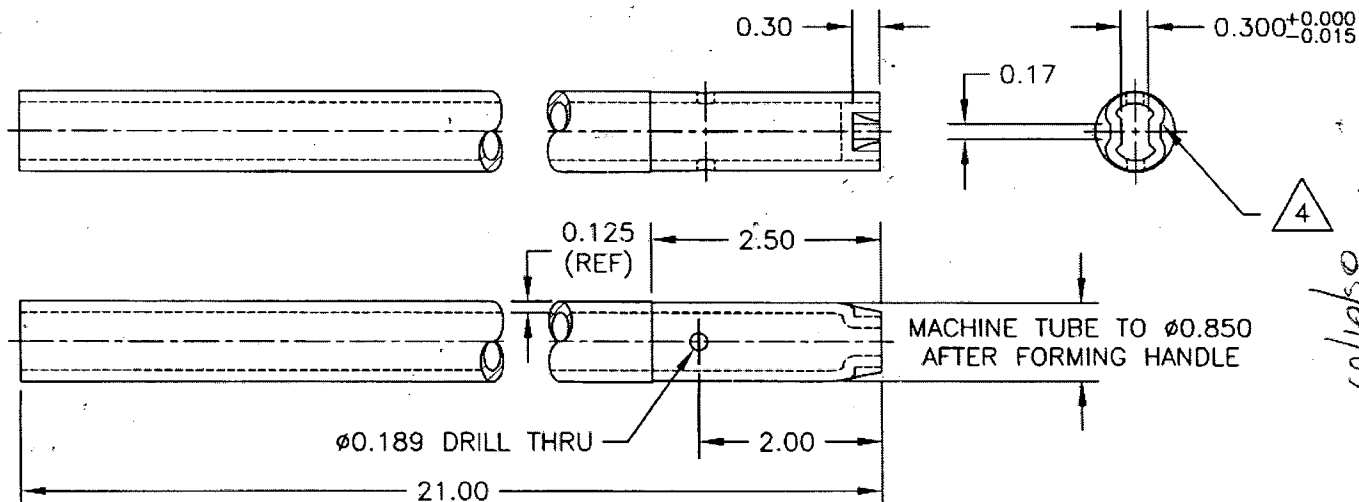




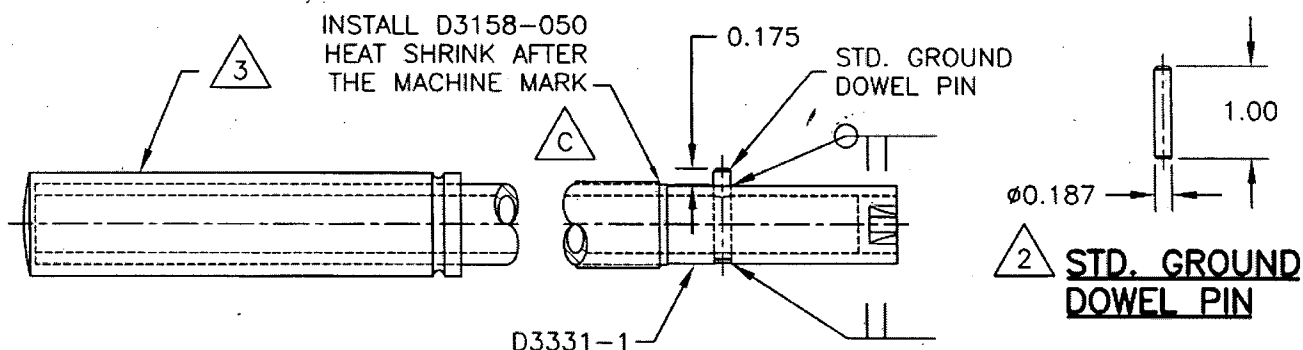


**DART**

RELEASED  
05/07/05



**D3331-1 HANDLE**



**D3331-041 HANDLE ASS'Y**

**NOTES:**

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097  
(REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN,  $\phi 3/16$ " x 1.00" LONG  
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
- 3) STD. BLACK VINYL GRIP,  $7/8$ " I.D. x  $4 \frac{3}{4}$ " LONG  
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM, USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.
05.05.20	05.05.20	D3331
DATE	05.05.20	TITLE
		HANDLE WELDMENT
A	04.11.29	NEW ISSUE
B	05.02.18	LENGTH 21.00 WAS 18.00
C	05.05.20	ADD D3158-050
		SCALE
		1:2
		REV. C
		SHEET 1 OF 1
		HAWKESBURY, ONTARIO, CANADA

WORK ORDER  
35440  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

